

Work Order ID 67448

Monday, March 21, 2011 1:47:00 PM

Page 1

Item ID: D3836-042

Accept

Setup Start

Revision ID:

Stop

Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 3/21/2011 Start Qty: 2.00

Required Date: 3/25/2011 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-03-21 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3836

Rev A

100

0.00



Large Fab

Large Fab

Memo

0.00

Large Fab

1- cut D3836-2 and D3836-3 rib as per dwg D3836

2- remove identification markings

3- deburr

4- weld D3836-2 to D3836-3 and drill hole (3/16") using DT9447 jig and open to finish size as per dwg D3836

5- weld D2327-3 spacer bushing as per dwg D3836

A/R ER316 S.S. Rod Batch: 115528

6- grind weld flush where indicated on dwg

SAD 11-04-22

PL 11.05.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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NOTE: Date & initial all entries

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Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00



QC

Memo

0.00

Quality Control

BE
11.05.05

2

0

140

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

S 11.05.05

x2

042

150

Identify as per dwg & Stock Location:

0.00



Packaging

Memo

0.00

Packaging

11.05.05

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Page 3

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Required Date: 3/25/2011 Req'd Qty: 2.00

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/5/5

ME
11-05-05

W/O:		WORK ORDER CHANGES					
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Picklist Print

Monday, March 21, 2011 1:47:05 PM

Page 1

Work Order ID: 67448

Parent Item: D3836-042

Parent Item Name: Rib Assembly (Basket Lid, RH)

Start Date: 3/21/2011

Required Date: 3/25/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 08-12-01 new issue DD verified by:cC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2327-3

Manufactured

No

100

Each

31.0000

1

2



Spacer Bushing



BC 11-03-04

Location

Loc Qty

Loc Code

WA005

31

58974

1

64920

2

66087

8

66535

20

2

M304TS0.750W.065

Purchased

No

100

f

1,099.377

1.7808

3.749053



SAD 11-04-22

304 SQ Tube .75x.75x.065W

Location

Loc Qty

Loc Code

WA007

1099.377169

116267

200.4298

116763

898.947369

3.7490

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

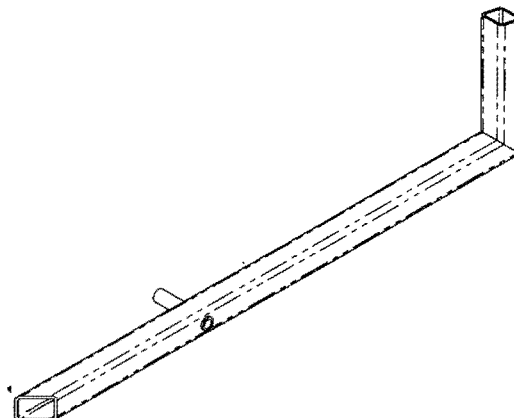
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

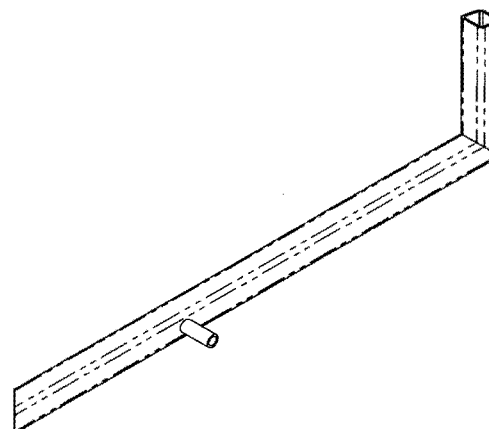
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ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3836-041	RIB ASSY (BASKET LID, LH)
2		X	D3836-042	RIB ASSY (BASKET LID, RH)
3	1	1	D2327-3	SPACER BUSHING
4	1		D3836-1	RIB
5		1	D3836-2	RIB
6	1	1	D3836-3	RIB



D3836-042 RIB ASSY (BASKET LID, RH)



D3836-041 RIB ASSY (BASKET LID, LH)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 67448

PA 11-03-21

RELEASED
08/09/24

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.99 lbs EACH
 - 8) WELD PER DART QSI 004

A	NEW ISSUE	MB	08.09.24
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.09.24		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3836	REV. A
TITLE RIB ASSY (BASKET LID)	SCALE NTS
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W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

7

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2

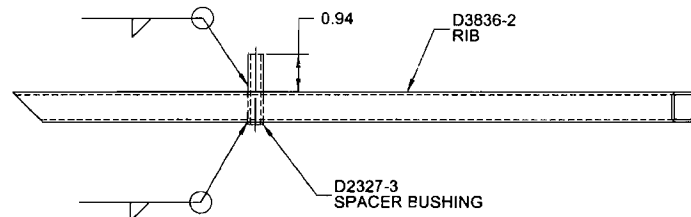
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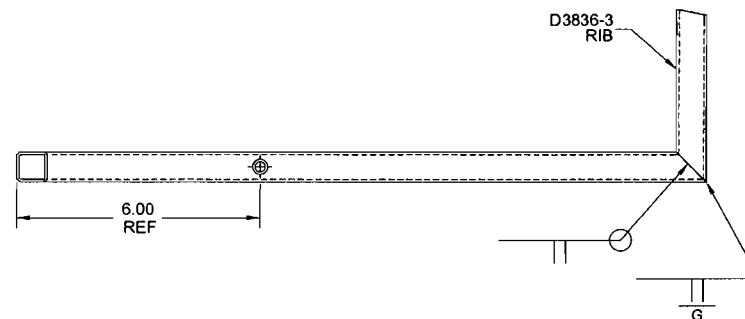
D3836-1
RIB

0.94

D2327-3
SPACER BUSHINGD3836-2
RIBD2327-3
SPACER BUSHING

C

C

D3836-3
RIB6.00
REFD3836-3
RIB6.00
REF

B

B

D3836-041 RIB ASSY (BASKET LID, LH)**D3836-042 RIB ASSY (BASKET LID, RH)**

w/o 67448

RELEASED
08/11/18 MRP

A

A

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3836	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		RIB ASSY (BASKET LID)	NTS
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8

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1

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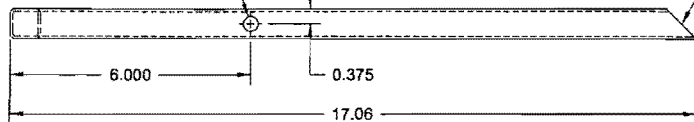
NOTE: Date & initial all entries

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CHAMFER

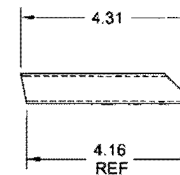


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0.75 X 45°
CHAMFER



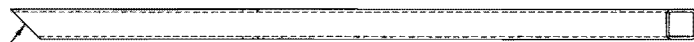
D3836-1 RIB



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CHAMFER

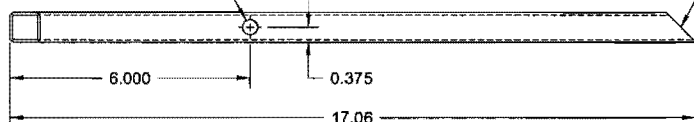
D3836-3 RIB

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CHAMFER

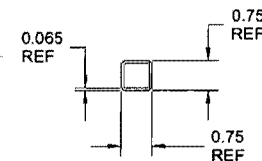


$\varnothing 0.375^{+0.020}_{-0.000}$ THRU

0.75 X 45°
CHAMFER



D3836-2 RIB



**TYPICAL SECTION
VIEW**

RELEASED
08/11/18

NOTES:

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SQUARE TUBE, 0.75 X 0.75 X 0.065 WALL
REF. DART SPEC. M304TS0.750W0.065
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3836-1/2 = 0.78 lbs EACH; D3836-3 = 0.19 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO. D3836	REV. A
MFG. APPR.		TITLE	SHEET 3 OF 3
APPROVED		RIB ASSY (BASKET LID)	SCALE
DE APPR.			NTS
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